



OPERATOR'S MANUAL

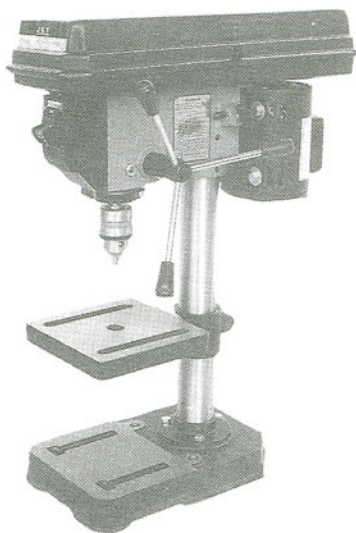
JDP-8 DRILL PRESS

Stock No. M-354066

OPERATING INSTRUCTIONS

Before operating the unit, please read this manual thoroughly, and retain it for future reference.

We thank you for your purchase of a JET Drill Press. It has been designed, engineered and manufactured to give you the best possible dependability and performance. However we'd like to remind you that faultless running is entirely dependent upon rational use and careful maintenance, which will also spare the user time consuming delays and costly repairs.



The model and serial numbers of your set are located on the front of the belt cover.

Record the serial number in the space provided below. Refer to these numbers in any correspondence relating to this product:

MODEL: _____

SERIAL NO.: _____

TABLE OF CONTENTS

General Safety Instructions	2
Additional Safety Rules	3
Specifications	4
Electrical Requirements	5
Getting to Know Your Drill Press	6
Assembly Instructions	7
Operations	
Installing Chuck	8
Removing Chuck & Arbor	8-9
Depth Stop	9
Spindle Speeds	9
Changing Spindle Speeds and Tensioning Belt	9-10
Return Spring Adjustment	11
Basic Operational Hints	11
Lubrication	11
Electrical Breakdown	12
Parts Breakdown	13
Parts List	14-15

WARNING!

Some dust created by power sanding, sawing, grinding, drilling, and other construction activities contains chemicals known [to the State of California] to cause cancer, birth defects or other reproductive harm. Some examples of these chemicals are:

- Lead from lead-based paints,
- Crystalline silica from bricks and cement and other masonry products, and
- Arsenic and chromium from chemically treated lumber.

Your risk from these exposure varies, depending on how often you do this type of work. To reduce your exposure to these chemicals: work in a well ventilated area, and work with approved safety equipment, such as those dust masks that are specially designed to filter out microscopic particles.

GENERAL SAFETY INSTRUCTIONS

1. **KEEP GUARDS IN PLACE.** Safety guards must be kept in place and in working order.
2. **REMOVE ADJUSTING KEYS AND WRENCHES.** Check to see that the chuck keys and adjusting wrenches are removed from tool before turning it on.
3. **REDUCE THE RISK OF UNINTENTIONAL STARTING.** Make sure switch is in the "OFF" position before plugging in the tool.
4. **DO NOT FORCE TOOLS.** They will do the job better and safer at the rate for which they were designed.
5. **USE RIGHT TOOL.** Do not force tool or attachment to do a job for which it was not designed.
6. **SECURE WORK.** Use clamps or a vise to hold work when practical. NEVER use hands to hold workpiece.
7. **MAINTAIN TOOLS WITH CARE.** Keep tools sharp and clean for the best and safest performance. Follow instructions for lubricating and changing accessories.
8. **DISCONNECT TOOLS FROM POWER.** Before servicing, or when changing accessories such as bits, blades, cutters, etc.
9. **USE RECOMMENDED ACCESSORIES.** Consult the owner's manual for recommended accessories. The use of improper accessories may cause injuries to operator.
10. **CHECK DAMAGED PARTS.** A guard or any part that is damaged should be carefully checked to determine that it will operate properly and perform its intended function. Check for alignment of moving parts, binding of moving parts, breakage of parts, mounting, and any other conditions that may affect its operation. A guard or any part that is damaged should be properly repaired or replaced.
11. **TURN POWER OFF. NEVER LEAVE TOOL RUNNING UNATTENDED.** Do not leave tool until it comes to a complete stop.
12. **KEEP WORK AREA CLEAN.** Cluttered areas and benches invite accidents.
13. **DO NOT USE IN DANGEROUS ENVIRONMENT.** Do not use power tools in damp or wet locations or expose them to rain. Keep work area well lighted.
14. **KEEP CHILDREN AWAY.** All visitors should be kept at a safe distance from work area.
15. **MAKE WORKSHOP CHILD PROOF.** Use padlocks, master switches, and remove starter keys.
16. **WEAR PROPER APPAREL.** Loose clothing, gloves, neckties, rings, bracelets or other jewelry may get caught in moving parts. Non slip footwear is recommended. Wear protective hair covering to contain long hair.
17. **ALWAYS USE SAFETY GLASSES AND DUST MASKS.** Use face or dust mask if cutting operation is dusty. Every day eyeglasses only have impact resistant lenses, they are NOT safety glasses.
18. **DO NOT OVERREACH.** Keep proper footing and balance at all times.
19. **NEVER STAND ON TOOL.** Serious injuries could occur if a moving part is unintentionally contacted.
20. **WOOD DUST CREATED BY CERTAIN WOODWORKING TOOLS CAN BE HAZARDOUS TO YOUR HEALTH.** Operate machinery in a well ventilated area. Use of a dust collection system is highly recommended.

ADDITIONAL SAFETY RULES FOR DRILL PRESSES

1. Operate drill presses only if you are familiar with its operation. If not, ask a qualified user.
2. Always shut off power to machine before making any adjustments.
3. Machine must be properly grounded. Be sure to check that electrical connections are compatible with machine.
4. Always check tightness of drill bit before operating. Failure to do so could cause damage to machine and/or operator.
5. Always remove chuck key from chuck before starting machine.
6. Always adjust table and/or depth stop to prevent drilling into table. It is highly recommended to use a backing piece when drilling through workpiece.
7. Secure workpiece to table with clamps or a vise to prevent rotating with the drill bit.

WARNING: Do not wear gloves when operating drill press; serious injury could result.

WARNING: Wear proper eye protection when operating this or any power tool.

**JET DRILL PRESSES
SPECIFICATIONS:**

JDP-8

Stock Number:	354066
Swing:	8"
Type:	Bench
Drilling Capacity:	3/8"
Chuck Size:	1/2"
Spindle Travel:	2"
Spindle Distance to Base:	10 1/8"
Spindle Distance to Table:	7 3/16"
Table Size Diameter:	6 3/8"
Table Tilt:	± 45°
Spindle Taper:	JT#33
Column Diameter:	1 7/8"
Spindle Speed:	5
Spindle RPM:	620-3100
Overall Height:	22 1/2"
Base Size:	7 3/8" x 11 1/2"
Motor:	1/6HP, 1Ph 115V U.L. Listed
Net Weight (approx):	40lbs.
Shipping Weight (approx):	44lbs.

electrical requirements

WARNING: TO AVOID INJURY FROM UNEXPECTED STARTUP, DO NOT USE BLOWER OR WASHING MACHINE MOTORS OR ANY MOTOR WITH AN AUTOMATIC RESET OVERLOAD PROTECTOR.

CONNECTING TO POWER SOURCE OUTLET

This machine must be grounded while in use to protect the operator from electric shock.

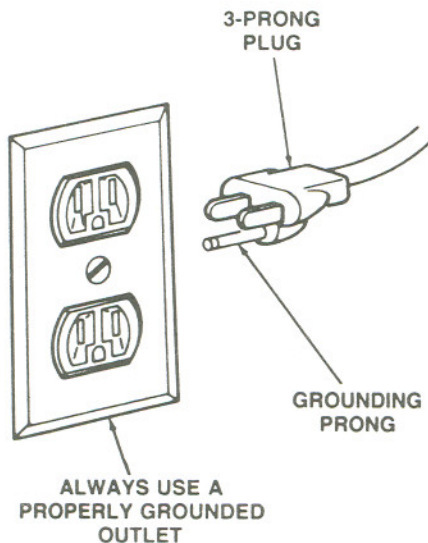
Plug power cord into a 110-120V properly grounded type outlet protected by a 15-amp. dual element time delay or Circuit breaker.

NOT ALL OUTLETS ARE PROPERLY GROUNDED. IF YOU ARE NOT SURE THAT YOUR OUTLET, AS PICTURED BELOW, IS PROPERLY GROUNDED, HAVE IT CHECKED BY A QUALIFIED ELECTRICIAN.

WARNING: TO AVOID ELECTRIC SHOCK, DO NOT TOUCH THE METAL PRONGS ON THE PLUG, WHEN INSTALLING OR REMOVING THE PLUG TO OR FROM THE OUTLET.

WARNING: FAILURE TO PROPERLY GROUND THIS POWER TOOL CAN CAUSE ELECTRICUTION OR SERIOUS SHOCK, PARTICULARLY WHEN USED IN DAMP LOCATIONS, OR NEAR METAL PLUMBING. IF SHOCKED, YOUR REACTION COULD CAUSE YOUR HANDS TO HIT THE CUTTING TOOL.

IF POWER CORD IS WORN OR CUT, OR DAMAGED IN ANY WAY, HAVE IT REPLACED IMMEDIATELY TO AVOID SHOCK OR FIRE HAZARD.



Your unit is for use on less than 120 volts. It has a plug that looks like the one above.

This power tool is equipped with a 3-conductor cord and grounding type plug, approved by Underwriters' Laboratories and the Canadian Standards Association. The ground conductor has a green jacket and is attached to the tool housing at one end and to the ground prong in the attachment plug at the other end.

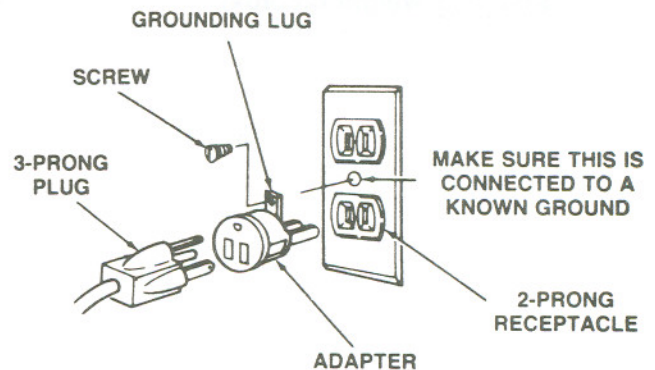
This plug requires a mating 3-conductor grounded type outlet as shown.

If the outlet you are planning to use for this power tool is of the two prong type, **DO NOT REMOVE OR ALTER THE GROUNDING PRONG IN ANY MANNER.** Use an adapter as shown and always connect the grounding lug to known ground.

It is recommended that you have a qualified electrician replace the TWO prong outlet with a properly grounded THREE prong outlet.

An adapter as shown below is available for connecting plugs to 2-prong receptacles.

WARNING: THE GREEN GROUNDING LUG EXTENDING FROM THE ADAPTER MUST BE CONNECTED TO A PERMANENT GROUND SUCH AS TO A PROPERLY GROUNDED OUTLET BOX.

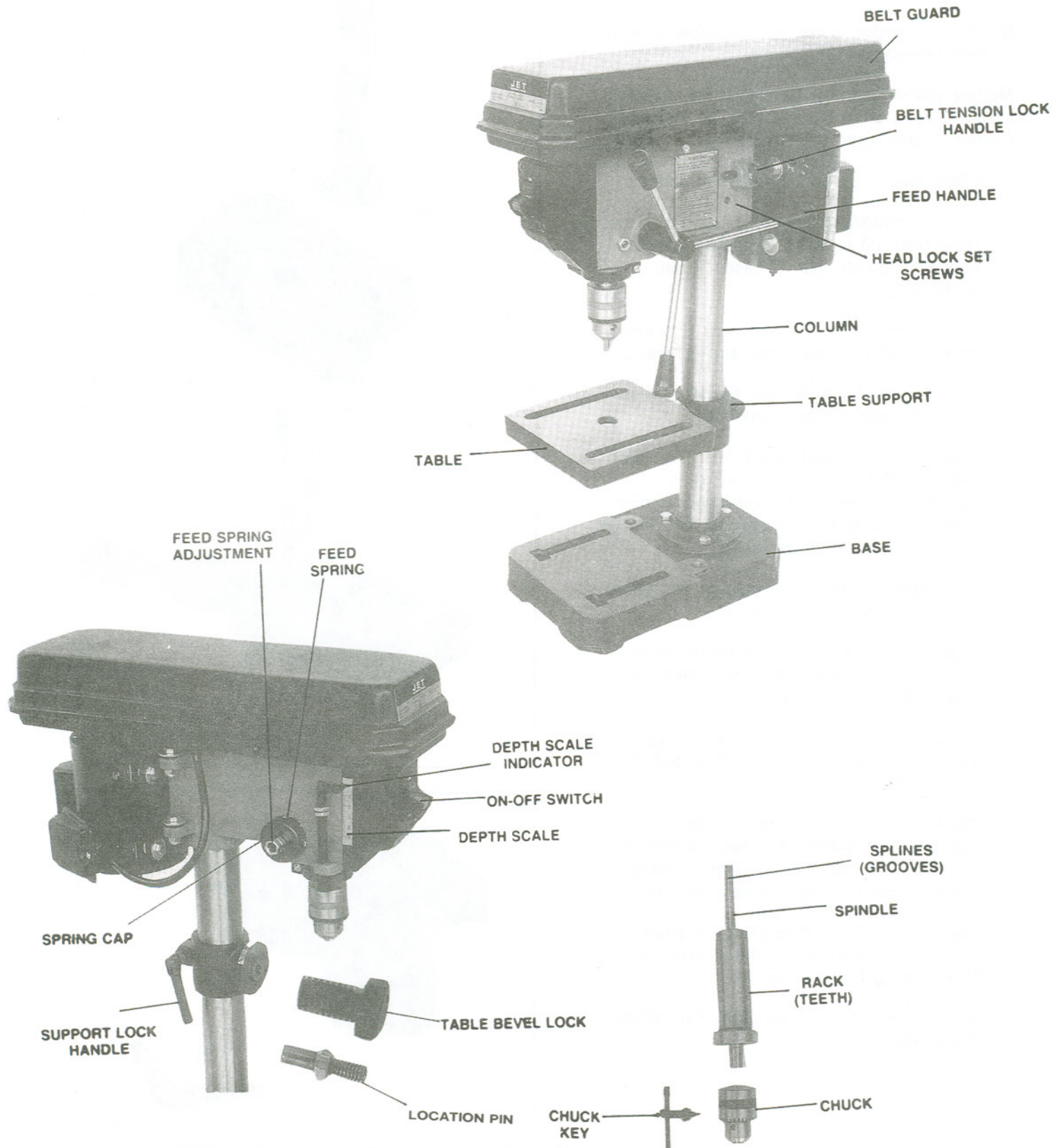


NOTE: The adapter illustrated is for use only if you already have a properly grounded 2-prong receptacle. Adapter is not allowed in Canada by the Canadian Electrical Code.

The use of any extension cord will cause some loss of power. To keep this to a minimum and to prevent overheating and motor burn-out, use the table below to determine the minimum wire size (A.W.G.) extension cord. Use only 3 wire extension cords which have 3-prong grounding type plugs and 3-pole receptacles which accept the tools plug.

Extension Cord Length	Wire Size A.W.G.
0-25 Feet	16
26-50 Feet	14
51-100 Feet	12

getting to know your drill press



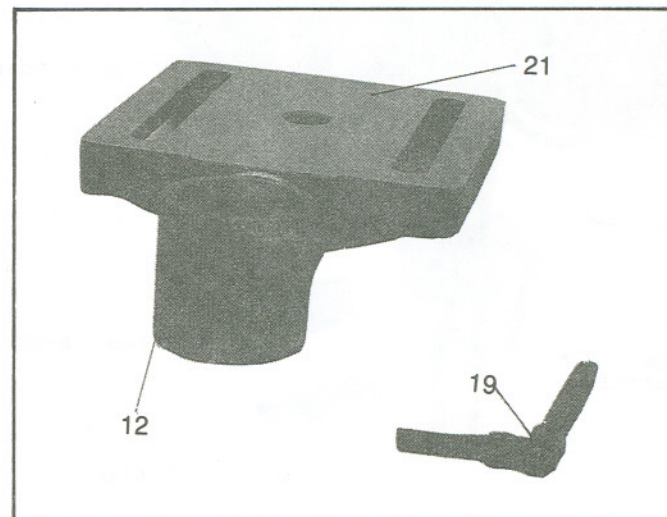
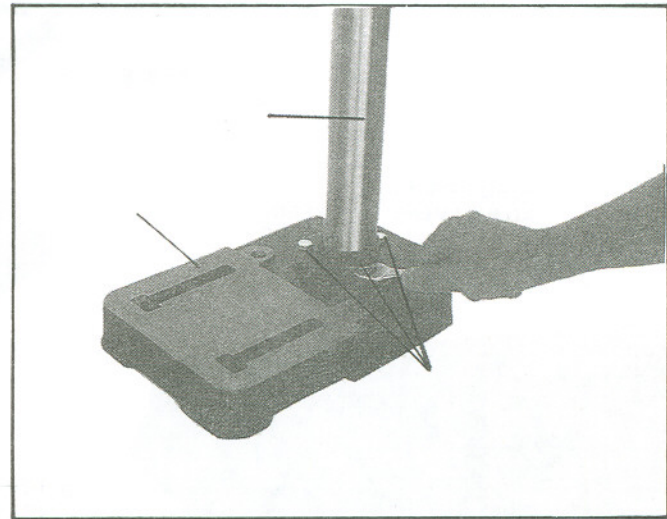
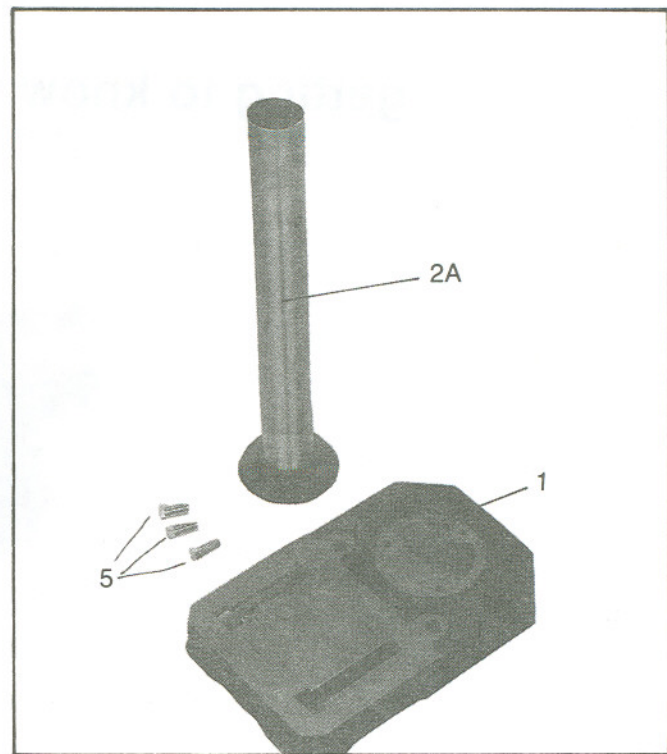
ASSEMBLY INSTRUCTIONS

Refer to parts breakdown and/or descriptive pictures for numbers indicated in ().

Some floor models come with the table bracket support already on the column.

Models JDP-8 and JDP-10 do not use a rack system. Slide table bracket support on these models directly onto column.

1. Place base (1) on flat and level surface.
2. Bolt column(2A)to base (1) using four hex head bolts (5) supplied. (position gear rack (22) to right side of base - where applicable).
3. Remove rack ring (23) and rack (22) from column using supplied hex socket wrench.
4. Install worm pinion (9) into bracket (6) so that both gears engage smoothly.
5. Slide rack (22) into bracket (6). Then slide this unfinished assembled unit onto column (1), (make sure unfinished portion of rack is positioned on top and that rack is seated properly in lower collar).
6. Slide rack ring (23) over column and fasten with hex socket screw (24).
7. Install crank handle (10) onto previously installed worm pinion (9) and tighten hex head bolt (11) with wrench.
8. Install column lock handle (19) through plain side of bracket (6) into threaded side and tighten.
9. Place head assembly (25) on top of column (2A). CAUTION! Head assembly is heavy - use two people or appropriate material handling equipment when lifting.
10. Align head (25) to base (1) and tighten to column (2A) with two socket screws (26) found on right side of head.
11. Install three handle bars (43A) into handle body (37).



12. Install table (21) into table bracket (12) and tighten table lock handle (19).
13. Install 60 watt (max.) light bulb (not included) into receptacle on bottom of head (25)

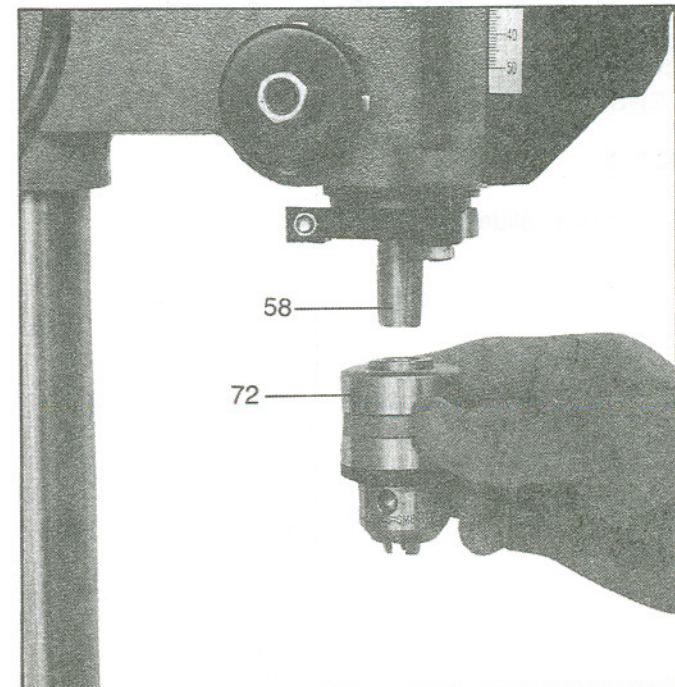
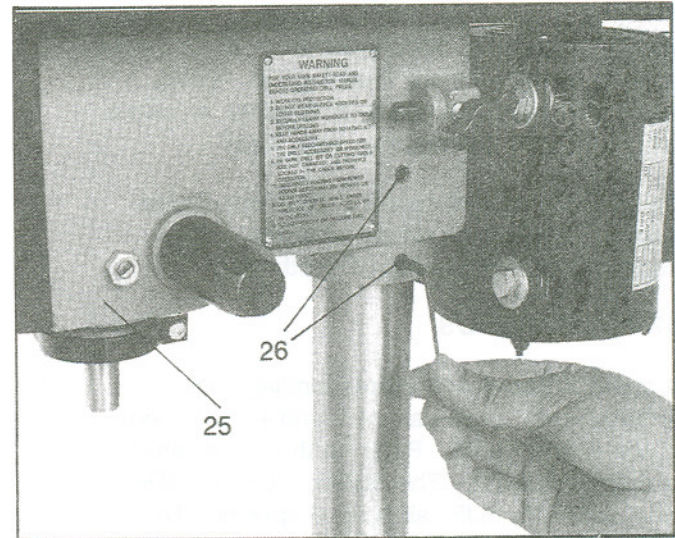
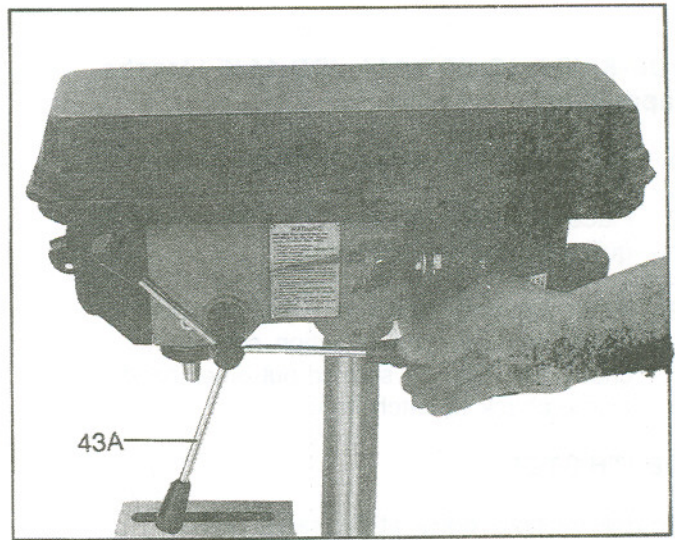
INSTALLING CHUCK

NOTE: JDP-8, JDP-10, JDP-14J and JDP-14JF are Jacobs tapered. The chuck mounts directly to the spindle. An arbor is not used. Make sure the arbor nose is clean of any oil or rust protectant before mounting chuck. On models equipped with a Morse taper make sure all rust protectant is cleaned off before inserting arbor. You can inspect this by lowering the quill, using the downfeed handles, and rotating the spindle until the knock out hole in the spindle lines up with the knock out hole in the quill.

1. Slide small end of arbor (71) into chuck (72A).
2. Place long end of arbor (71) into spindle (58). Rotate arbor to line up tang with spindle.
3. Raise table (21) to within 5 inches of chuck. Place a block of wood on table and lower chuck assembly to block of wood with handle bar assembly (43A).
4. Press firmly to set assembly in spindle.

IMPORTANT: Spindle, arbor, and drill chuck have to be clean of protective grease. Chuck and spindle may not seat properly if these parts are not clean.

REMOVING CHUCK AND ARBOR



JDP-8, JDP-10, JDP-14J, JDP-14JF (Jacobs taper #33)

1. Leave quill (56) in fully retracted position.
2. Place a pickle-type fork between bottom of quill (56) and top of chuck.
3. While applying pressure equally to both sides, increase prying action slowly until chuck falls off. Be sure to put other hand below chuck to catch it.

DEPTH STOP

To drill multiple holes at the same preset depth, use the depth stop (no's. 610-618)

To set depth stop, simply advance bit to lowest desired depth with the feed handle. Using your other hand, advance nuts (614) on depth stop until they are snug to seat (611).

Spindle will now advance only to this preset depth. To release, simply advance nuts counterclockwise to top of depth stop.

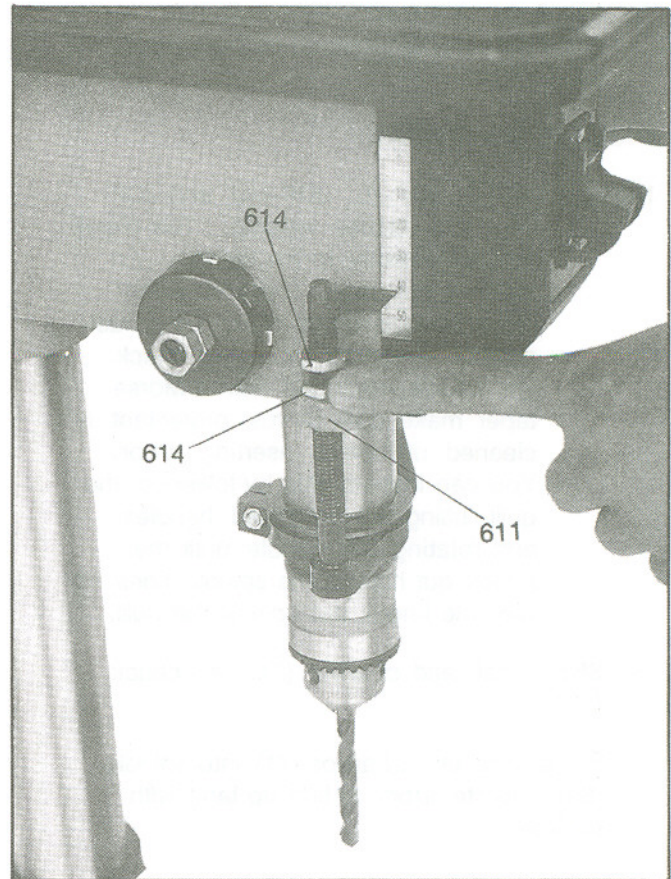
SPINDLE SPEEDS

A spindle speed and corresponding belt arrangement chart can be found on the inside of the pulley guard. Refer to this chart when changing speeds. The JDP-8, JDP-10, JDP-14J, and JDP-14JF all have 5 speeds. The JDP-14M, JDP-17M, and JDP-14MF all have 16 speeds. The JDP-20MF has 12 speeds.

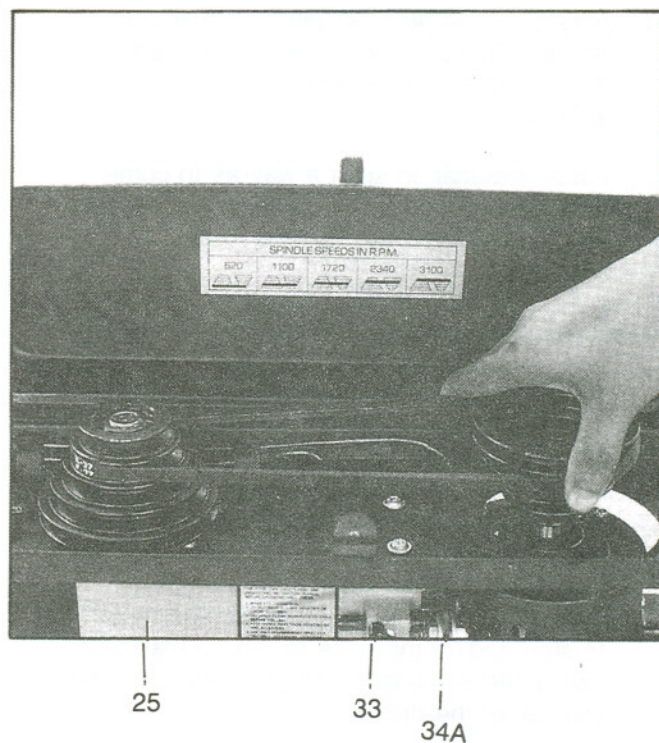
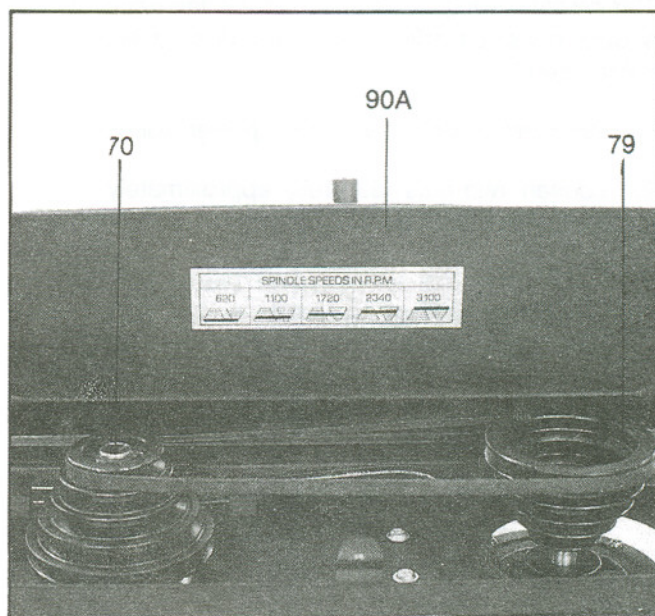
CHANGING SPINDLE SPEEDS AND TENSIONING BELT

JDP-8

1. Loosen slide bar bolt (33).



2. Press motor base (34) to back of head (25) and hold (base is spring loaded).
3. Change belts to desired position on motor pulley (79) and spindle pulley (70). Reference speed charts (165) on inside of pulley cover assembly (90A).
4. Position motor base (34) to allow for approximately 1/2" deflection by thumb pressure at midpoint between pulleys.
5. Tighten slide bar bolt (33).



RETURN SPRING ADJUSTMENT

The return spring is adjusted at the factory and should not need adjustment. If it does, follow these steps.

1. Disconnect drill press from power source.
2. Loosen two nuts (53, 106) approximately 1/4". Do not remove.
3. Firmly hold coil spring cover (49A); pull out and rotate until pin on return spring plate (52) engages with next notch in coil spring cover (49A). Turn counterclockwise to increase tension and clockwise to decrease tension.
4. Tighten two nuts (53, 106) to hold in place - do not overtighten. Nuts should not contact housing when tight.

BASIC OPERATIONAL HINTS

1. Always use a back-up piece of material (wood). This protects the bit and the table. It also prevents splintering of the workpiece.
2. Place material in such a way as to come into contact with the left side of the column. This will prevent the material from spinning.

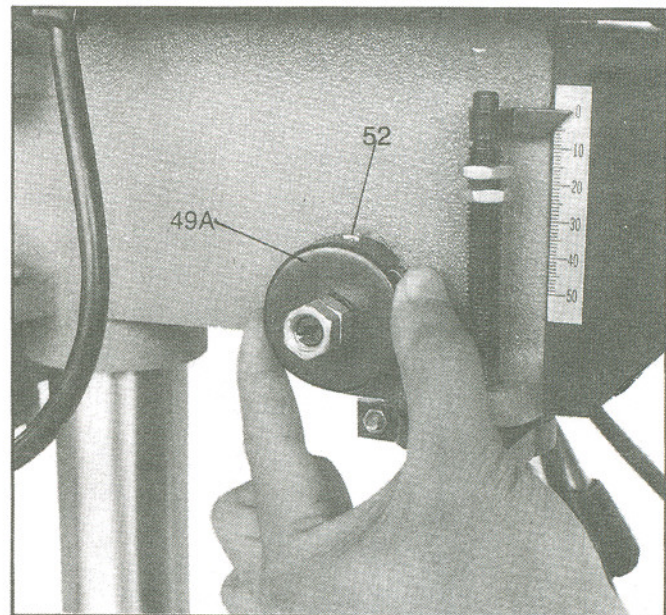
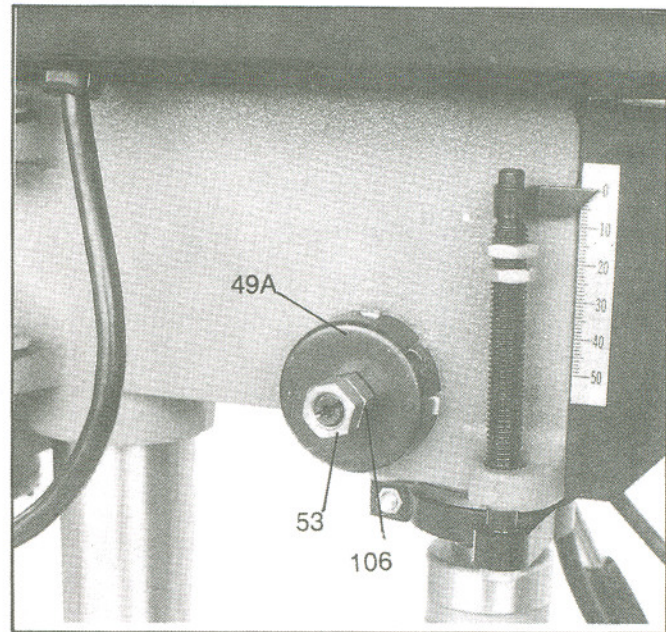
WARNING: If workpiece is not long enough, use a clamp or drill press vise that is securely fastened into the table. Failure to do so may cause serious injury.

3. Feed bit into material with only enough force to allow drill bit to work. Feeding too slowly may cause burning of workpiece. Feeding too quickly may cause the motor to stop and/or the belts to slip. It may also cause the workpiece to break free from its clamps or the drill bit to break.
4. Generally speaking, the smaller the drill bit, the greater the RPM required. Wood will require higher speeds than metal. Metal is usually drilled at slow speeds.
5. In dusty environments, frequently blow out any dust that accumulates inside the motor.

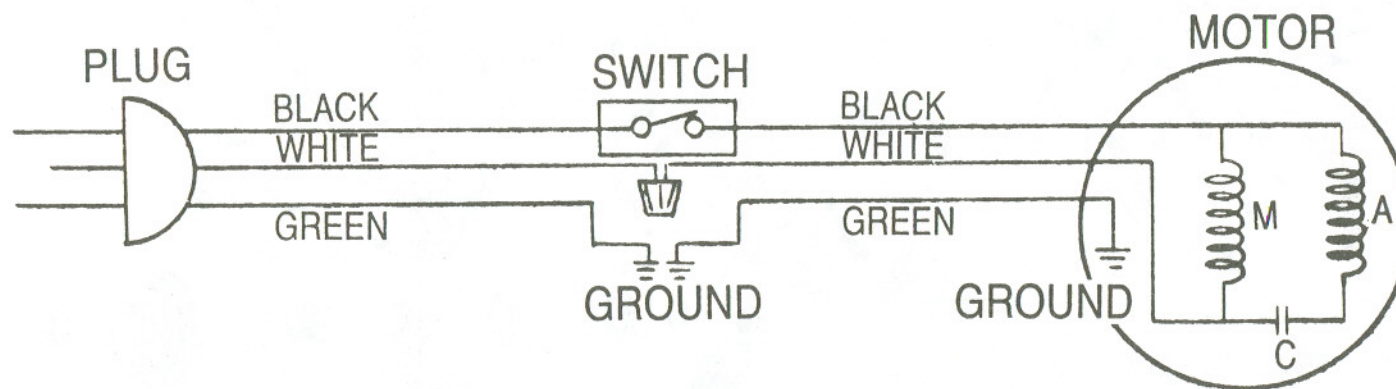
LUBRICATION

All motor ball bearings are permanently lubricated. No further lubrication is necessary.

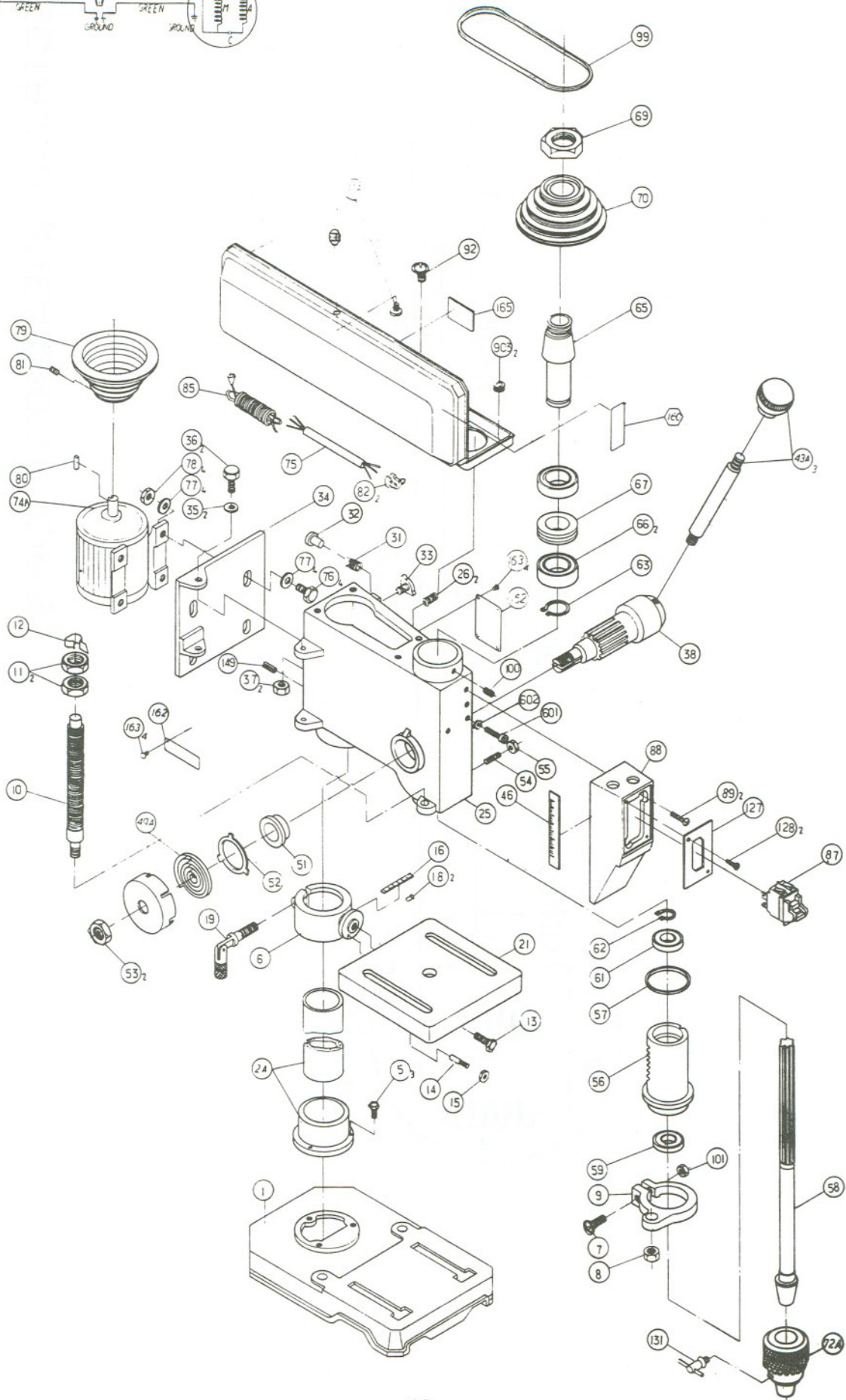
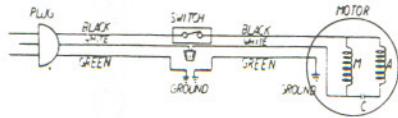
Periodically lubricate the splines (grooves) in the spindle (58) and teeth of the quill (56).



ELECTRICAL BREAKDOWN/JDP-8



PARTS BREAKDOWN DIAGRAM JDP-8



PARTS LIST MODEL JDP-8

INDEX#	PART#	PART NAME	REMARKS	QUANTITY
1	10200102	Base		1
2A	10200404A1	Column & holder ass'y	φ 48	1
5	2601BZDA56	Hex. hd. bolt	M8×1.25-25	3
6	10200601	Table bracket		1
7	2669BZDA27	Pan. hd. screw	M5×0.8-20	1
8	2701FZD106	Hex. nut	M6×1.0-5	1
9	10200905	Set ring		1
10	10201004	Scale bolt		1
11	2701FZD111	Hex. nut	M10×1.5-T4	2
12	10201209	Pointer		1
13	2601QBDS81	Hex. hd. bolt	1/2"×12UNC-7/8"	1
14	10601401	Locator pin	1/4"-30	1
15	2701QZD506	Hex. nut	1/4"-20UNC	1
16	10201602	Angle scale		1
18	2658MZDU36	Drive screw	φ 2.3-5	2
19	10602001	Table handle lock		1
21	10202102	Table		1
25	10202536	Head		1
26	2603BBLA52	Headless set screw	M8×1.25-8	2
31	10303101	Spring	M8×1.25-16	1
32	10203215	Slide bar		1
33	10303303	Slide bar bolt	M8×1.25-15	1
34	10603422	Motor base		1
35	2501NZDN32	Spring washer	1/3"×29/32-5/64	2
36	2601BZDA56	Hex. hd. bolt	M8×1.25-25	2
37	2705FZD108	Lock nut	M8×1.25	2
38	10203824	Feed shaft		1
43A	10204306A2	Handle bar ass'y		3
46	10204602	Scale		1
49A	10204930	Coil spring & cover		1
51	10205113	Spring seat		1
52	10305206	Plate		1
53	2701QZD609	Hex. nut	φ 3/8×24UNF	2
54	10205405	Quill set screw		1
55	2701FZD111	Hex. nut		1
56	10205601	Quill		1
57	10305701	Rubber washer		1
58	10205803	Spindle		1
59	2001ZZ6201	Ball bearing	6201ZZ	1
61	20015Z6201	Ball bearing	6201Z	1
62	2570BBN111	Retaining ring		1
63	2570BBN117	Retaining ring		1
65	10206522	Driving sleeve		1
66	20015Z6203	Ball bearing		2
67	10306701	Collar		1
69	10306901	Pulley set nut		1
70	10207003	Spindle pulley		1
72A	C0014170110	Chuck include 131 key		1
74	8203120204	Motor		1
75	2808B537H2	Motor cable	0.75×3C UL	1
76	2601BZDA54	Hex. hd. bolt	M8×1.25-16	4
77	2501NZDN26	Flat washer	5/16×7/8-5/64	8
78	2701FZD108	Hex. nut	M8×1.25 T=6	4
79	10207904	Motor pulley		1
80	2571NNC204	Key	3/16×3/16-0.79	1
81	2603BBLA36	Headless set screw	M6×1.0-6	1
82	2801CBHA01	Strain relief		2
85	2807BB06H2	Cable	0.75×3C UL	1
87	2898D05G04	Switch		1
88	10208827	Switch box		1
89	2669BZDA24	Pan hd. screw	M5×0.8-12	2

